

Work Order ID 87086

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87086

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Item ID: D2530 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment
 Start Date: 8/20/12 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 8/20/12 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: Date: 120711 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2530	Rev B								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Cut to length as per Dwg D2536								
	2-Deburr								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R S.S. rod Batch: <u>M162323</u>	0.00							
120	Small Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

13-04-08 DD

10 0 13-04-09 10

10 13-04-09 10

DAS
19
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				(10)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(10)			
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 3:50 OVEN TEMPERATURE: 320 °F FINISH TIME: 4:20	0.00 0.00							

ml23480

10 X 10 m/f 13/04/16

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Picklist Print

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Work Order ID: 87086

Parent Item: D2530

Parent Item Name: Handle Weldment

Start Date: 8/20/12

Required Date: 8/20/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F 11.01.07 chg qc 5 to 6
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq iD	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2534 Lock Plate		Manufactured	No			120	Each	40.0000	2	10		13-04-08	PD
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA		40		897737 => (25)					
				81878		20							
				86370		20							
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	686.9558	2.9145	15.339474		13-04-08	PD
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT017		686.955794		M25065 => (30.678)					
				109314		9.333							
				111619		3							
				112187		4							
				112800		11							
				114852		2.75							
				116108		3							
				117797		0.75							
				120441		0.000794							
				121170		234.89							
				121666		18.232							
				122312		400							

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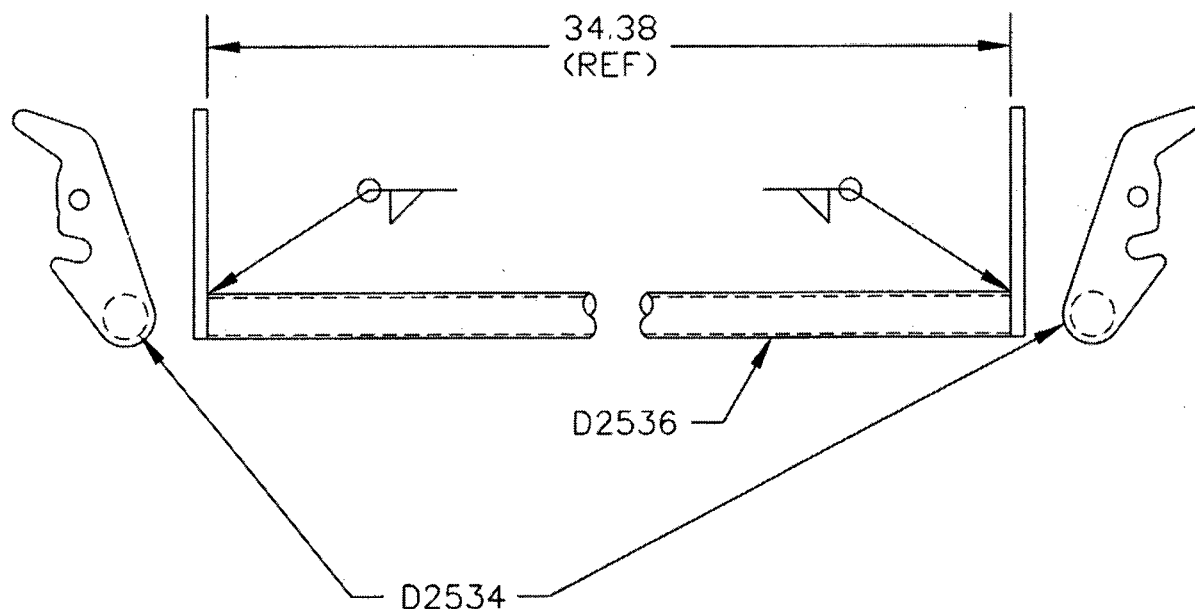
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2530	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	SHEET 1 OF 1	
DATE 04.12.14		TITLE HANDLE WELDMENT	
A	96.06.18	NEW ISSUE	
B	04.12.14	UPDATE NOTES AND DIMENSIONS	

RELEASED
04.12.16 *[Signature]*

PART LIST -- D2530

87086
RD/2071

QTY	PART NUMBER	DESCRIPTION
X	D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE



D2530 HANDLE WELDMENT

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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